

Work Order ID 84532-2

May-15-12 10:55:30 AM

\*84532\*

Page 1

Item ID: D4151-7

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 5/15/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/16/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4151

C

100

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.960" long

110

0.00

\*110\*

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-MILL as per folio FA952 & dwg.

FOLIO REV: AA

DWG REV: C

2-Deburr as required

6

0

12/05/15

4

0

12/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 84532

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\*84532\*

Page 2

Item ID: D4151-7

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Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 5/15/12

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/16/12

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

4 0 12/05/16

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

12/05/16

4 0

140

Identify as per dwg & Stock Location: *Solve*

0.00

\*140\*

Packaging

Memo

0.00

Packaging

4x 80 12-5-17

150

QC 21 -

12/05/17

12/05/17

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

May-15-12 10:55:29 AM

Page 1

Work Order ID: 84532

Parent Item: D4151-7

Parent Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 5/15/12

Required Date: 5/16/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD  
revC DD verf:JLM IPP Rev:B 11.01.21 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750 303 BAR 2" X 1.750"		Purchased	No			100	f	3.0053	0.26	1.6421053		12/15/15	

Location

Loc Qty

Loc Code

MAT050

3.005263

118535

3.005263

→ 121 766

1.500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	57752
<b>Description: Fwd Eyebolt Receiver (Upper)</b>		<b>Part Number:</b>	<b>D4151-7</b>
<b>Inspection Dwg: D4151</b>	<b>Rev: C</b>		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 12/05/16	Date: 12/05/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.08.25	Tolerance revised for dimension 0.800	KJ	
C	11.07.26	Dimensions revised per Dwg Rev C	KJ	M



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

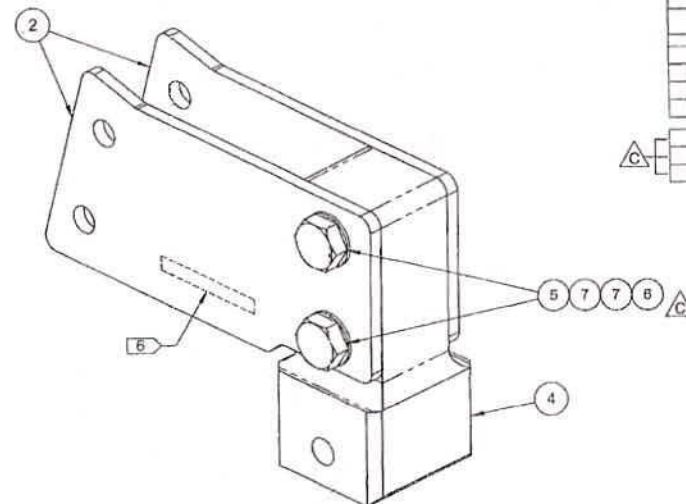
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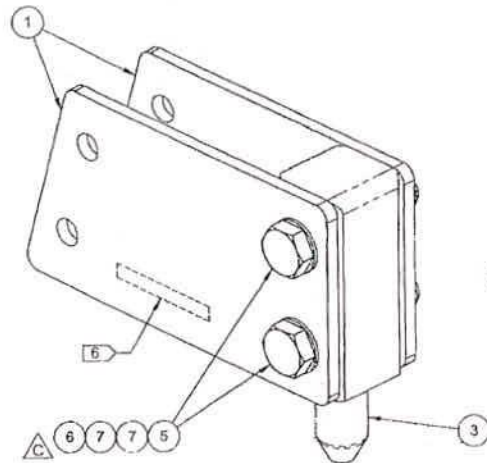
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**NOTE:** Date & initial all entries





**D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)**



**D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
  - D4151-041 = 0.88 lbs
  - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

C	AN4 HARDWARE WAS AN3 (B8-1, C3-1 & D3-1); Ø0.262 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C5-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3811-1 (ZN B8-1 & D3-1); D4151-7 WAS D3811-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-0399-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C  
SHEET 1 OF 3  
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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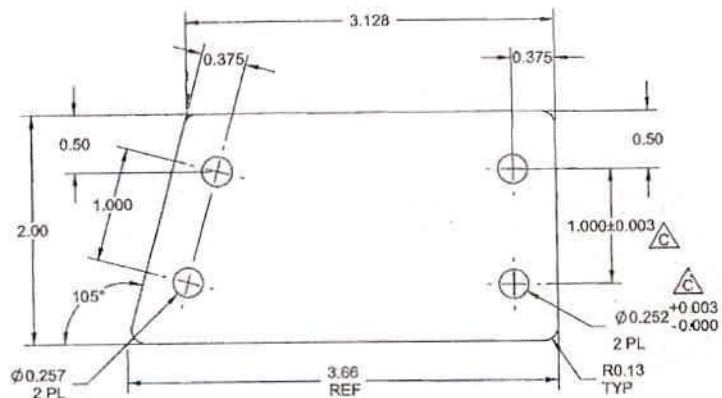
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

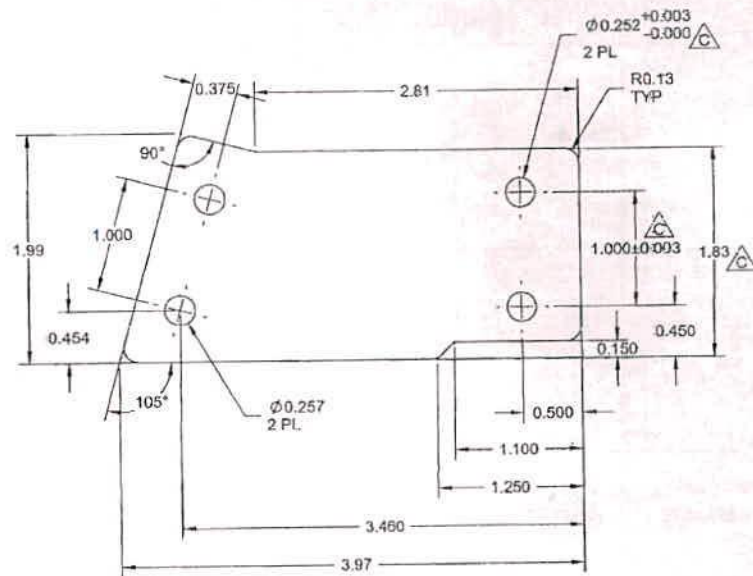
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**NOTE:** Date & initial all entries



0.125  
REF

**D4151-1 LOWER HARDPOINT PLATE**



0.125  
REF

**D4151-3 UPPER HARDPOINT PLATE**

**NOTES:**

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4151</b>	SHEET 2 OF 3
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DE APPR.		<b>BASKET FWD HARDPOINT</b>	NTS
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2011-01-18  
MD



# Dart Aerospace Ltd

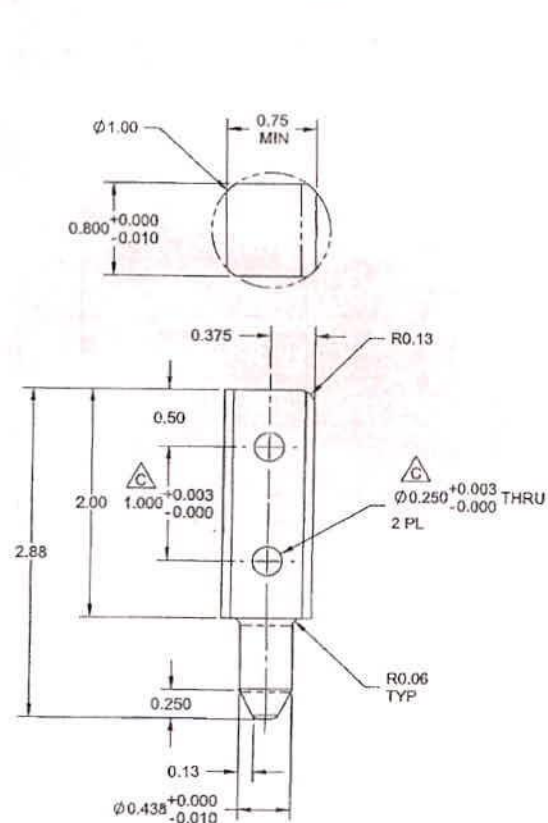
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

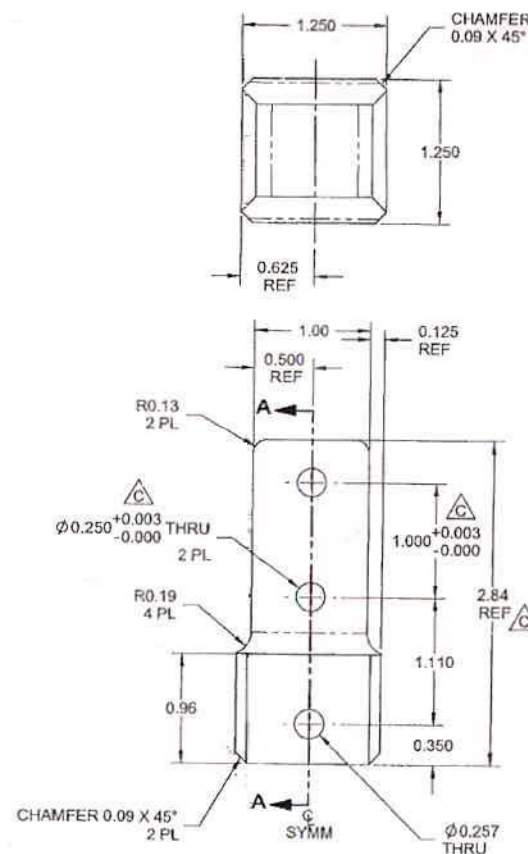
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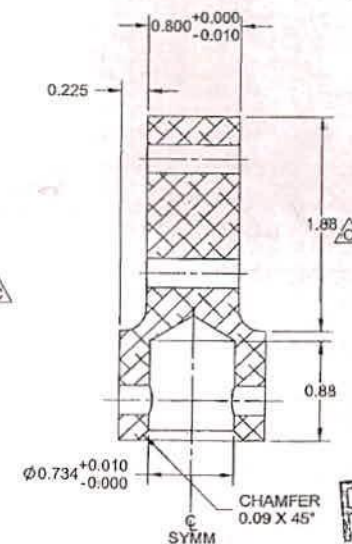
**NOTE:** Date & initial all entries



**D4151-5 FWD BASKET INSTL STUD (LOWER)**



**D4151-7 FWD EYEBOLT RECEIVER (UPPER)**



**SECTION A-A**

**NOTES:**

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs  
-7: 0.70 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4151</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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2011-03-30  
**RELEASED**

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